



U.S. Army Research, Development and Engineering Command

# TT-C-490 –Implementing alternatives through specifications



***TECHNOLOGY DRIVEN. WARFIGHTER FOCUSED.***

Tom Braswell, Fred Lafferman, John Kelley,  
Tom Considine, Chris Miller, William Lum,  
John A. Escarsega  
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- 1. Background and Motivation for TT-C-490
- 2. Strategy for Over-Arching Specifications
- 3. Details of the Specification
- 4. Closing Comments



Prior to 2013, TT-C-490 was  
“Chemical Conversion Coatings and  
Pretreatments for Ferrous Surfaces  
(Base for Organic Coatings)”



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INCH-POUND

TT-C-490E  
July 22, 2002  
SUPERSEDING  
TT-C-490D  
March 31, 1993

## FEDERAL SPECIFICATION

### CHEMICAL CONVERSION COATINGS AND PRETREATMENTS FOR FERROUS SURFACES (BASE FOR ORGANIC COATINGS)

This specification was approved by the Assistant Administrator  
Office of Federal Supply and Services, General Services  
Administration, for the use by all Federal Agencies.

#### 1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers cleaning, surface conditioning for crystal refinement and pretreatment by chemical conversion of ferrous metals and zinc/zinc alloy coated metals. The application of chemical conversion and pretreatment coatings provides uniformly textured substrates for receiving and retaining paint, lacquer, etc. In addition, this specification covers suitable cleaning processes for nonferrous surfaces (see 6.1, 6.1.2).

1.2 Classification. This specification covers the following cleaning methods and surface preparation processes:

1.2.1 Surface cleaning. Surface cleaning should be by any of the following methods as specified (see 6.4):

Method I	Mechanical or abrasive cleaning.
Method II	Solvent cleaning by immersion, spray or vapor.
Method III	Hot alkaline cleaning by immersion, spray or electrolytic methods.
Method IV	Emulsion with or without added water.
Method V	Alkaline derusting.
Method VI	Phosphoric acid (alcohol, detergent or solvent type with detergent).

1.2.1.1 Ozone depleting chemicals. The cleaning material should not contain any chemical, which is classified in the Clean Air Act Amendments of 1990 as a Class I or Class II ozone depleting substance.

1.2.2 Conversion coatings and pretreatments. Chemical conversion and pretreatment coatings should be of the following types as specified (see 6.4).

Type I Zinc phosphate spray application (150 mg/ft<sup>2</sup> min - 500 mg/ft<sup>2</sup> max)

Zinc phosphate immersion or dip application (300 mg/ft<sup>2</sup> min - 500 mg/ft<sup>2</sup> max)

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Director, U.S. Army Research Laboratory, Weapons and Materials Research Directorate, ATTN: AMSRL-WM-M, Aberdeen Proving Ground, MD 21005-5069 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

AREA MFFP

- Pretreatments specific for ferrous substrates
- Specifies either zinc phosphate conversion coating or wash primer conforming to DOD-P-15328 or MIL-C-8514
- Wash primers contain hexavalent chromium
  - Also high in VOCs and contain HAPs
  - Only pretreatment allowed for multi-metal application
- Zinc phosphate is either applied by immersion or spray in a contained area



# Major Gaps in TT-C-490E Pretreatments



- Other than DOD-P-15328 & MIL-C-8514, there was no other pretreatment approved for multi-metal application
  - No approved alternatives to wash primer
- Most users do not have facilities large enough to apply zinc phosphate to structures and hulls
- Material compatibility issues (heat, acids, etc)
  - Hydrogen embrittlement risks perceived with WP and Phos
- No avenue to evaluate, approve, and adopt new technologies
- Direct-to-metal is not approved for CARC
  - Limited exemption by waiver

# Motivation to update TT-C-490

- TT-C-490 became outdated and used beyond original scope
- Restrictive language limits process improvements and prevents innovation
  - Lock-step procedures dictate material selections
  - Proven technologies are available and being used in commercial industries
- John J. Young Jr., The Office of the Undersecretary of Defense, memo (April 8, 2009) mandating reduction in chrome has led to elimination of TT-C-490 Type III (DoD-P-15328) on most new contracts
  - Impending cancellation of Type III DoD-P-15328
- *Technologies demonstrated for military applications (e.g.: ESTCP WP-200906) have no avenue other than waivers to use materials and processes outside specification*
- Engineering drawings specific to TT-C-490 process have forced OEM's to get PM approvals on materials not yet evaluated by ARL



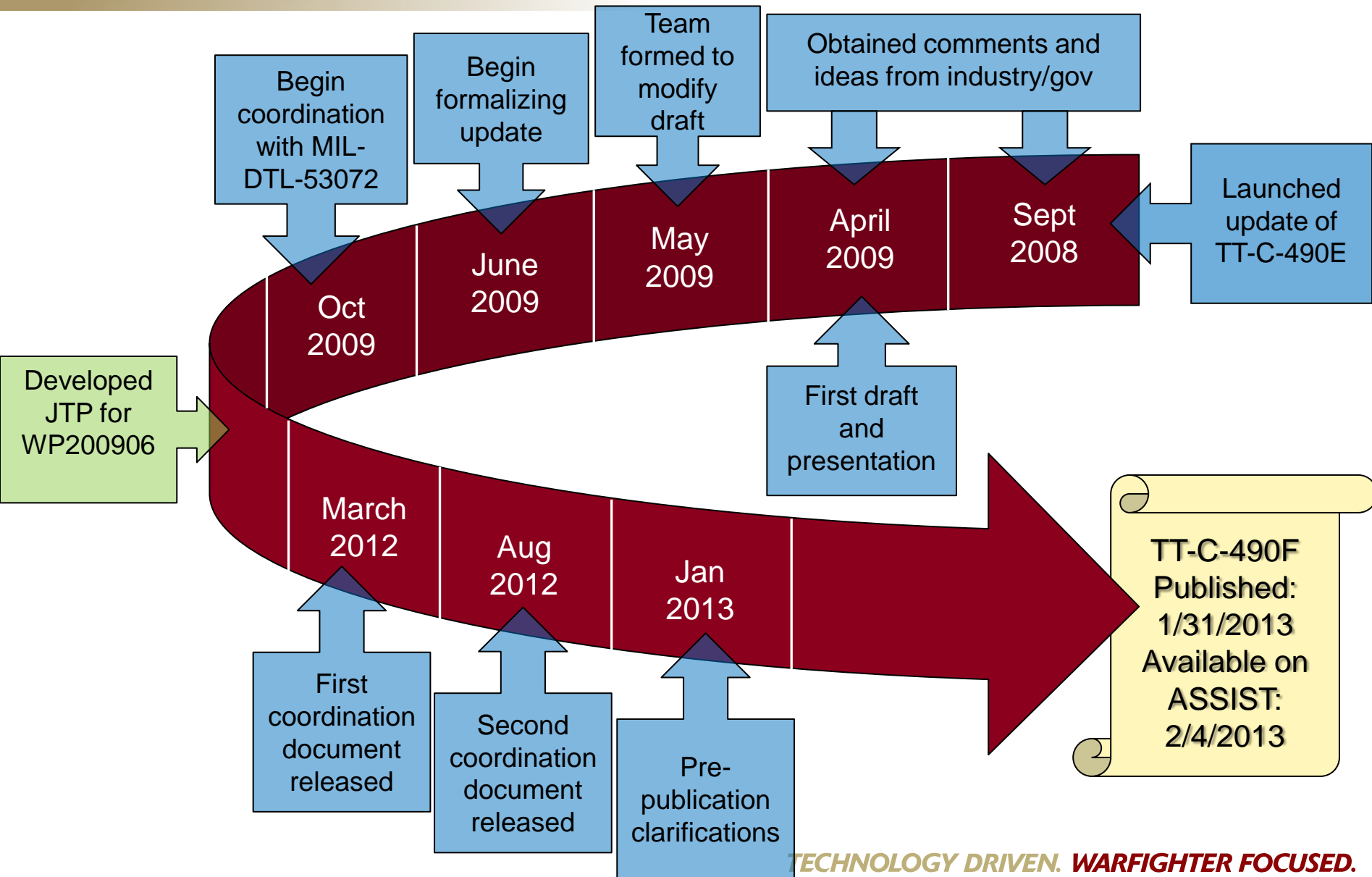
## TT-C-490E, “Chemical Conversion Coatings and Pretreatments for Ferrous Surfaces (Base for Organic Coatings)”



- Overarching document referenced in tens of thousands of military specifications and drawings
- The definitive reference for engineers to specify cleaning and pretreatment of ferrous materials
  - Often used improperly for cleaning non-ferrous metals
- Major gaps existed between the technologies permitted in TT-C-490E and what is available today
  - Prohibited use of chromated wash primer and eventual cancellation leaves technology gap for large components and multi-metal assemblies
- TT-C-490 is used by all services and OEMs for finishing metal



# Revision Timeline



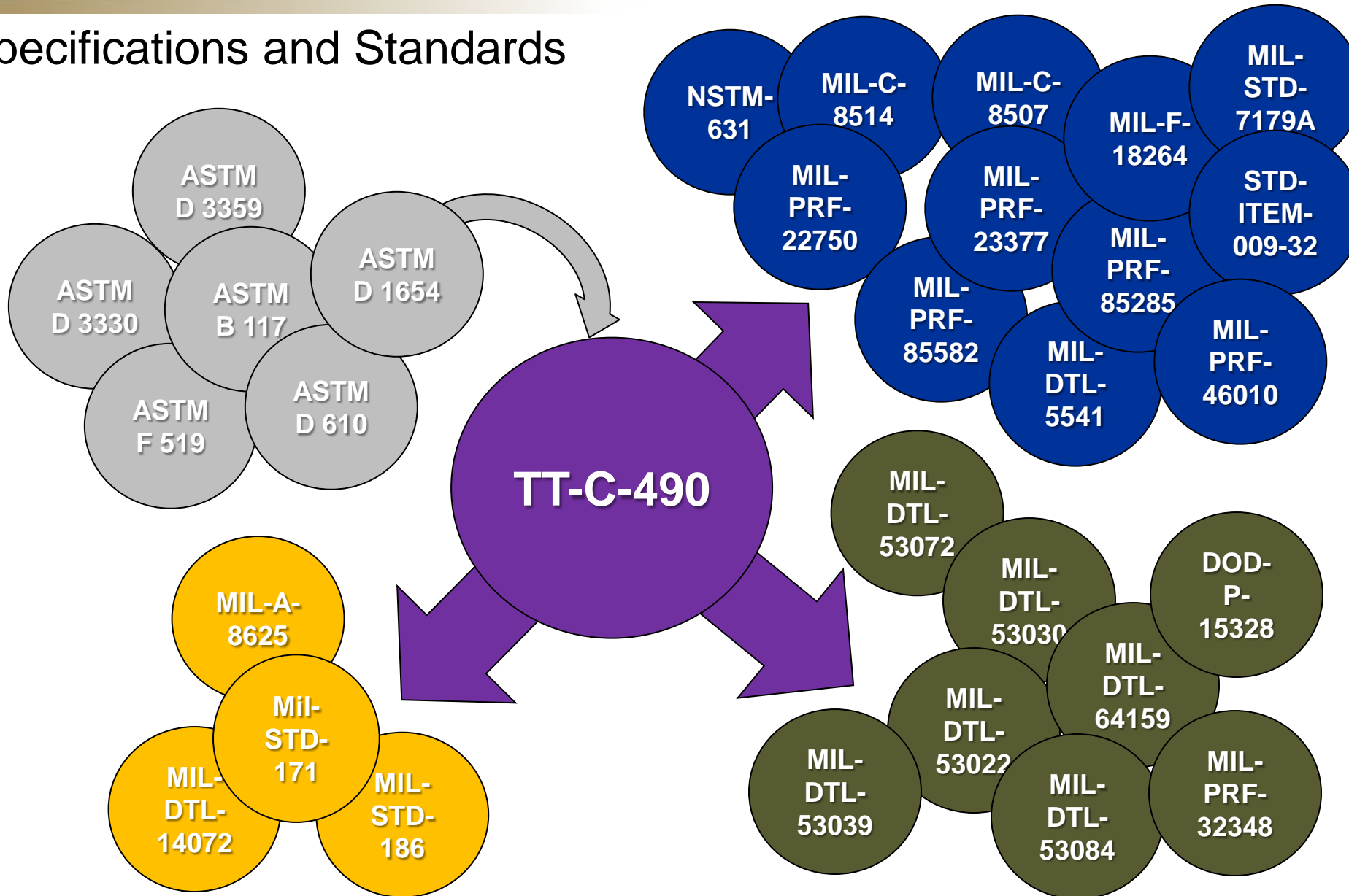
Team Member	Contribution
Thomas Braswell	TT-C-490F Team Lead
Fred Lafferman	Coatings Technical Lead
Bernie Hart (retired)	Specification and Standards
William Lum	Specification Coordinator
Thomas Considine	Corrosion Testing Standards
Christopher Miller	Subject Matter Expert TT-C-490E
John Kelley	Corrosion Team Facilitator

- **TT-C-490F will require Objective Quality Evidence (OQE)**
  - Continuous monitoring... “Tell me, show me, prove it”
  - Requires the use of certifiable process checks (ISO 9001/17025) to demonstrate competencies
  - Replaces “old” quality system which did not adequately control ongoing quality production
    - Government had insufficient resources to follow-up
    - No more “set and forget” production lines
  - **Applies to both legacy and new systems**
    - New systems also require qualification through QPD
- **TT-C-490F bolsters the quality of legacy zinc phosphate systems while maintaining integrity of the original processes including optional on-site inspection**
- **Incorporation of non-ferrous substrates embraces new technologies**
- **Enables the use of new approved technologies without the need for negotiating within contract**
- **ARL steward of QPD**

What does this all mean to DOD and its contractors?

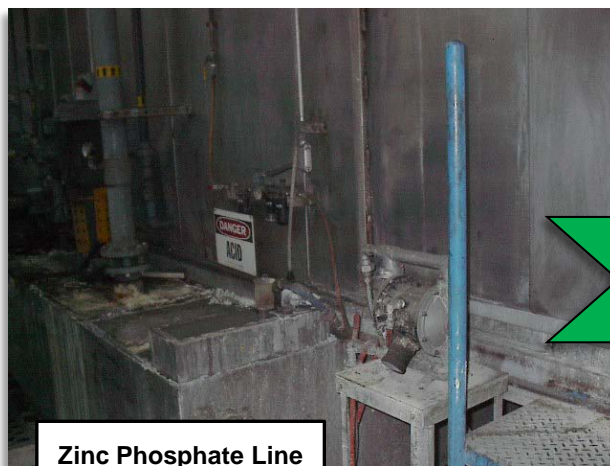
- **TT-C-490F augments requirements in MIL-DTL-53072**
- More flexibility in terms of pretreatment choices
  - ***First Fed specification to encourage the use of new technologies for multiple metal substrates***
- New TT-C-490 technologies can be applied through Engineer Change Notice (ECN) without changes to main drawings (drawing changes = \$\$\$\$)
- Greener technologies
  - Significant step towards elimination of  $\text{Cr}^{6+}$ , VOC's and HAP's
  - Reduced energy costs for operating pretreatment lines
  - Reduced wastes (little or no sludge removal/maintenance)
- In some cases, vastly better performance (zinc-rich)
- Applied program of quality assurance OQE
- ARL stewardship
  - Provides QPD for approved materials
  - Formal path for evaluating new materials and processes
  - Encourages innovation

## Specifications and Standards



## Example of Potential Cost Savings

	Zinc Phosphate 125°F (52°C)	Iron Phosphate 125°F (52°C)	Advanced Pretreatment 70°F (21°C)
Chemical Cost	\$100	\$100	\$100
Heating Energy	\$100	\$100	\$70
Electric Energy	\$100	\$86	\$71
Rinsing Water	\$100	\$100	\$40
Waste Disposal	\$100	\$35	\$17
Maintenance	\$100	\$25	\$15
	<b>\$600</b>	<b>\$446</b>	<b>\$313</b>

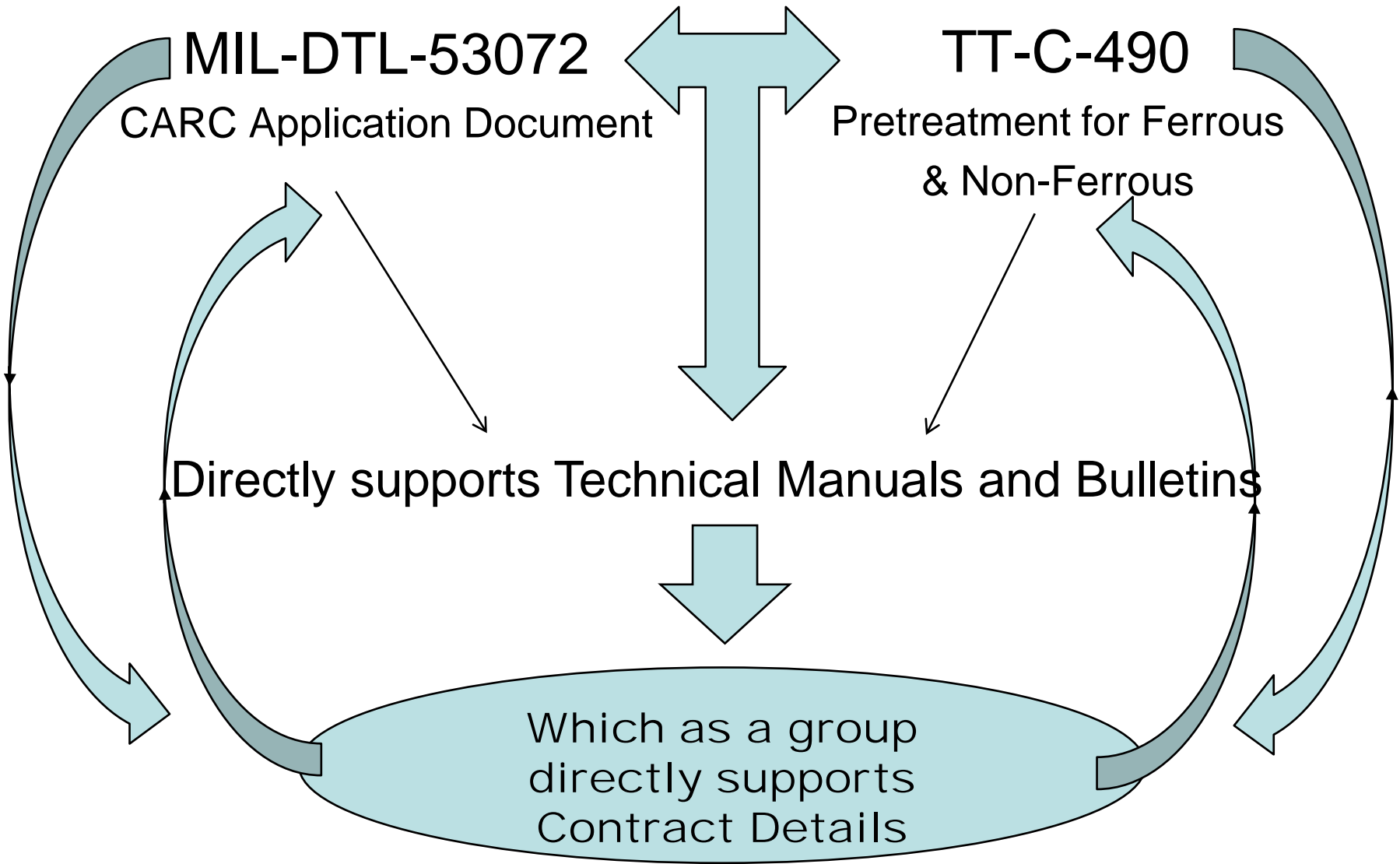


## Foundation for MIL-DTL-53072

- Chemical Agent Resistant Coating (CARC) consists of four distinct steps:
  - Cleaning and Preparation of Substrate (TT-C-490)
  - Pretreatment (TT-C-490)
  - Priming
  - Top-coating



# Over-Arching Specifications



- New Types that require qualification and inclusion in Qualified Products Database:
  - Type III – Organic pretreatments (chromate free)
  - Type IV – Inorganic pretreatments (silanes, zirconates, etc)
  - Type VIII – Metal-rich coatings for abrasive blasted surfaces
- Zinc phosphate, iron phosphate and current wash primers are legacy systems and do not require TT-C-490 QPD
- Statements of composition (full disclosure) and process requirements required for qualification
- QPD will be based upon Type, Class, and Cleaning Method
- Performance criteria established in specification and must be compatible with CARC primers
- QPD is transition from specification to implementation



# Qualification of New Technology

1

- Complete all required testing
- Pass all requirements for TT-C-490F
  - *(Type IV Inorganic Pretreatment)*

2

- Manufacturer submits Letter of Intent
  - Specify Type and Class
  - Provide full disclosure

3

- TT-C-490F Team Review of documentation
  - Approved and placed on QPD

- Expected questions from users:
  - What is the transition method to implement new pretreatment technologies?
    - Approval to TT-C-490F requirements
    - ARL initiates a formal QPD program
      - Legacy products not affected
  - Will it effect government drawings and contracts?
    - No effects on existing drawings and contracts
      - Can use ECNs to access new technologies
    - Enables new technologies to be used in future contracts
  - Will the new technologies cost more?
    - Generally, no
    - Enhanced performance products may increase costs
      - i.e.: zinc metal

- Overarching document referenced in tens of thousands of military specifications and drawings
- Requires continuous monitoring to provide objective quality evidence (OQE).
  - *Bolsters quality of legacy systems like phosphate*
- Encompasses both ferrous and non-ferrous substrates
- ARL stewardship provides formal process for evaluating and approving new materials for QPD
- ***Expedites implementation of new approved technologies by providing a QPD***
  - *No need for negotiating within contract*
  - *Implementation strategy for WP200906 and TMR-12-01*

Type I - Zinc phosphate.

Type II - Aqueous iron phosphate.

Type III - Organic pretreatment.

Type IV - Inorganic pretreatment.

Type V - Medium weight zinc phosphate.

Type VI - MIL-DTL-5541, Chemical  
Conversion Coatings on Aluminum and  
Aluminum Alloys.

Type VII - Anodic coating and electrolytic  
passivation.

Type VIII - Metal-rich coating for abrasive  
blasted surfaces

- ❖ Specifications are just one link to many elements to support implementation and use of new technologies.
- ❖ Posture is to reduce the number of “types” in specification to ensure only top level performance.
- ❖ Request and Mandate OEMs, Vendors and DOD do not restrict or isolate a particular technology.....reference the specification and select what works best for each end-user.



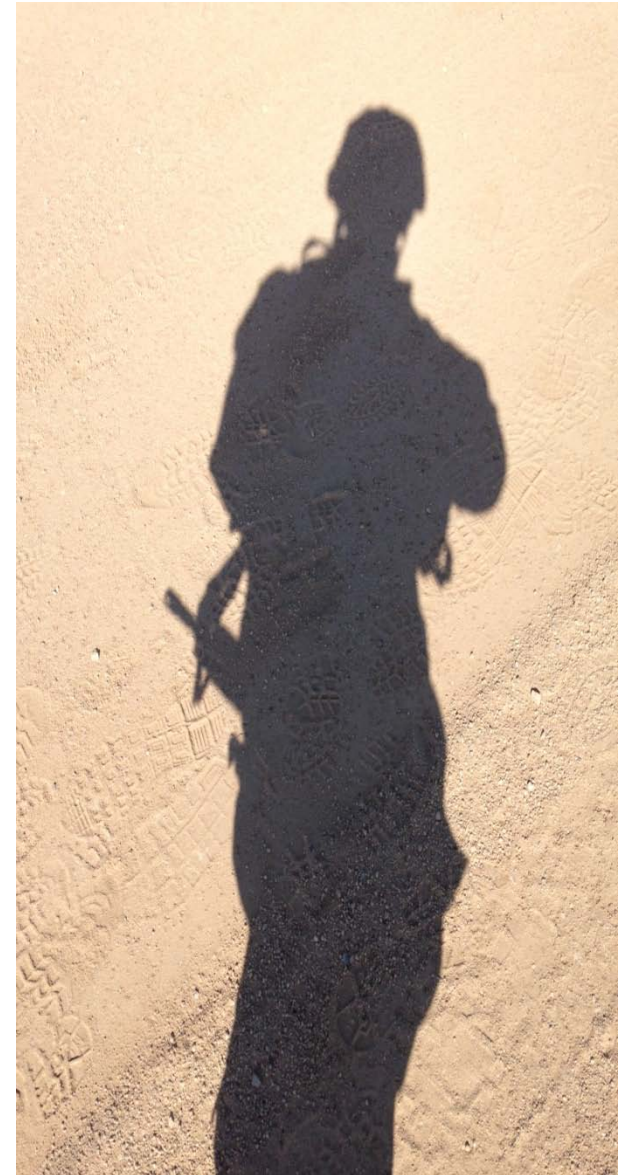
# Stakeholders/Contributors



## TT-C-490F Reconstruction Contributors

Contributor	Organization
John Escarsega	US Army Research Laboratory, MMSD-CARC Commodity Manager, Signature approving Authority
William Lum	US Army Research Laboratory, MMSD-Coatings Team, APG, MD 21005
Fred Lafferman	US Army Research Laboratory, MMSD-Corrosion Team, APG, MD 21005
Chris Miller	US Army Research Laboratory, MMSD-Corrosion Team, APG, MD 21005
Brian Plazankis	US Army Research Laboratory, MMSD-Corrosion Team, APG, MD 21005
Tom Considine	US Army Research Laboratory, MMSD-Corrosion Team, APG, MD 21005
Tom Braswell	US Army Research Laboratory, MMSD-Corrosion Team, APG, MD 21005
Scott Grendal	US Army Research Laboratory, APG, MD 21005
Jonathan Montgomery	US Army Research Laboratory, APG, MD 21005
Bernard Hart (retired)	US Army Research Laboratory, MMSD-Coatings Team, APG, MD 21005
Jack Kelley	US Army Research Laboratory, MMSD-Corrosion Team, APG, MD 21005
Gary Nelson	Chemetall Inc
Randall Brady	Deft Coatings
Chuck Ray	Deft Coatings
Mike Berger	Henkel
George Newton	Henkel
Pat Scalera	Henkel
John Mort	Hentzen Coatings
Terry Tuttle	Hentzen Coatings
Wes Prince	Impreglon Corp.
Amy Fowler	Naval Air Warfare Center, Patuxant River, MD
Randy Terrill	NCP Coatings
Matt Flory	Sherwin Williams
Nabil Zaki	Surtec Inc
Bernie Tucker	Tucker Liquid Ind. Coatings
Joe Menke	Corrosion Engineer, RIA
Carl Handsy (retired)	TARDEC
Jeff Adams	AMZ Corporation

Contacts	Telephone	Email
Thomas Braswell	410-306-0935	Thomas.braswell2.civ@mail.mil
Fred Lafferman	410-306-1520	fred.lafferman.civ@mail.mil
John Escarsega	410-306-0693	john.a.escarsega.civ@mail.mil
William Lum	410-306-0706	william.s.lum.civ@mail.mil
Thomas Considine	410-306-2564	thomas.a.considine.ctr@mail.mil
Christopher Miller	410-306-0849	christopher.e.miller44.civ@mail.mil
John Kelley	410-306-0837	John.v.kelley8.civ@mail.mil



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